



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3296-1
Job Sheet 187243



Part No: D3296-1

Job Qty: 10 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		12/13/18	0.03	1.04	Waterjet - Flow		SC 18/12/18
120	QC	10 pcs		12/13/18	0.00	0.00	QC8		10 10-12-20
140	HandFinish	10 pcs		12/13/18	0.00	0.53	HandFinish1		D.R. 18/12/21
150	QC	10 pcs		12/13/18	0.00	0.00	QC7-2		38
160	Packaging	10 pcs		12/13/18	0.00	0.00	Packaging3		21
170	QC21-SA	10 Ea		12/13/18	0.00	0.00	QC21		21

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	6.5960 sf (.6596 ea) 72556	100-Waterjet - Flow - 1	5101798

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	7	70	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.080inches ± 0.030	5.110 5.050		
2	Door Panel	0.060inches ± 0.030	0.090 0.030		
3	Door Panel	0.300inches ± 0.010	0.310 0.290		
4	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128		
5	Door Panel	16.400inches ± 0.005	16.405 16.395		
6	Door Panel	0.300inches ± 0.010	0.310 0.290		
7	Door Panel	13.400inches + 0.005 - 0.030	13.405 13.370		
8	Door Panel	17.000inches ± 0.030	17.030		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

			16.970
9	Door Panel	14.180inches $\pm$ 0.030	14.210 14.150
10	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290
11	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053

Plex 11/29/18 10:00 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ I Fab ☐ hing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date : _____		MRB (QSI042) _____	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S138944 Part: D3296-1 Job No: 187243 Serial No/Batch: S138944 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/19/18		Completed By _____	
		Lead hand / Supervisor _____	
		QC / QA Coordinator _____	
Manufacturing _____ Equip/Tooling _____ Handling/Preservation _____ Material _____ Product Improvement _____ Process Improvement _____ Human Factors _____	Crushing _____ Cracks _____ Crimp/Kink/Ripple/Wave/Twist _____ Marks/Chatter _____ Mislabeled _____ Contamination _____ Misaligned/off center _____ BOM/Route _____ Broken/Damage/Defect _____ Incomplete/Unclear Instructions _____ Drill Holes _____ Fit/Function _____ Power Loss/Surge _____ Folio/Program _____ Grain Direction _____ Weld _____ Wrong Stock Pulled _____ Out of Sequence _____ Off-set/Set-up _____ Positioned Wrong _____ Outside Tolerance _____ Drawing _____ Finish _____ Part Lost/Missing _____ Misread _____		
Other/Details: _____			